

Work Order ID 56577

Monday, March 01, 2010 3:01:49 PM



Page 1

Item ID: D2938-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 3/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-3-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2938	Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

DIP 10/03/08

6

0

MW 10/03/09

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

DIP 10/03/08

MW

10/03/09

6

0

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

DIP 10/03/08

MW

10/03/09

6

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

mk 10/03/09

6 0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

JH 10/03/10

X6 0

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

=> JH 10/03/10

(X6) 0

Powder Coating

START TIME: 10:30 AM OVEN TEMPERATURE:

11:00 AM FINISH TIME: 3:09 PM

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Item ID: D2938-1

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Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 3/2/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 3/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BK 10-3-10

⑥ φ

170

Identify as per dwg & Stock Location: 428A

0.00



Packaging

Memo

0.00

Packaging

R 10/3/11 ⑥

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11 DJ

mf

10-3-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Monday, March 01, 2010 3:01:49 PM

Page 1

Work Order ID: 56577



Parent Item: D2938-1



Parent Item Name: Saddle LH Out, 206

Start Date: 3/2/2010

Required Date: 3/15/2010

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	34.0000	6.0000			



Saddle Billet, 7075

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

46410

34

34

6 DJP 10/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 56577
Description: 206 Saddle, Outboard, Left side		Part Number: D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.110	.113	.113	.116		
B	0.100	0.140		0.115	.115	.118	.114		
C	0.100	0.140		0.115	.117	.115	.113		
D	0.210	0.230		0.220	0.219	0.220	.219		
E	1.245	1.255		1.250	1.247	1.247	1.250		
F	1.245	1.255		1.250	1.247	1.247	1.248		
G	2.495	2.505		2.500	2.497	2.498	2.498		
H	0.510	0.515		.511	.511	.512	.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.259	0.259	0.259	.258		
L	0.312	0.317		0.314	.314	.314	.314		
M	0.235	0.240		.236	.236	.236	.235		
N	0.100	0.140		0.108	0.108	0.109	.109		
O	0.540	0.560		0.547	.547	.548	.548		
P	0.490	0.510		0.497	.500	.497	.498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.735	2.740	2.740	2.740		
S	0.240	0.270		0.247	.246	.245	.243		
T	0.100	0.180		0.130	.134	.135	.134		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.317	0.317	0.317	.317		
X	1.250	1.270		1.2635	1.266	1.267	1.266		
Y	1.565	1.585		1.572	1.582	1.583	1.580		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DTJ / MVW
Date: 10/03/08 / 10/03/09

Audited by: smk
Date: 10/03/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 56577
Description: 206 Saddle, Outboard, Left side		Part Number: D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	3	4		
A	0.100	0.140		.114	.114				
B	0.100	0.140		.115	.116				
C	0.100	0.140		.116	.115				
D	0.210	0.230		.219	.219				
E	1.245	1.255		1.247	1.247				
F	1.245	1.255		1.247	1.247				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.512	.512				
I	1.572	1.582		1.574	1.574				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.257	.257				
L	0.312	0.317		.317	.317				
M	0.235	0.240		.235	.234				
N	0.100	0.140		.111	.109				
O	0.540	0.560		.547	.547				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.710	3.710				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		.244	.243				
T	0.100	0.180		.137	.133				
U	1.625	1.635		1.629	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.317	.317				
X	1.250	1.270		1.266	1.267				
Y	1.565	1.585		1.581	1.579				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>MMF</i>
Date: 10/03/09

Audited by: <i>Emf</i>
Date: 10/03/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

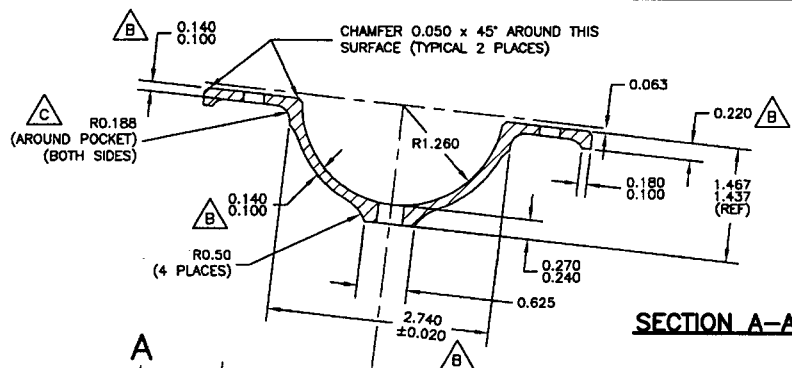
W/O:		WORK ORDER CHANGES					
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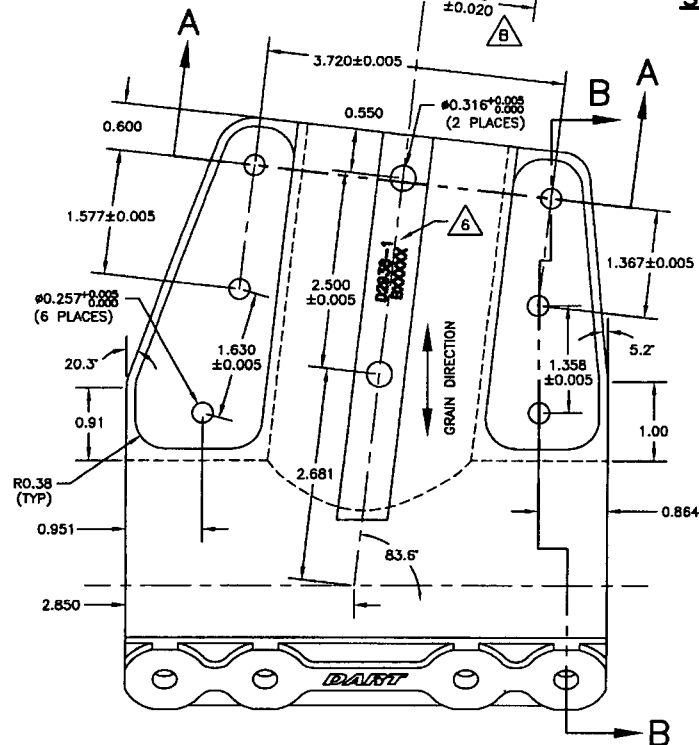
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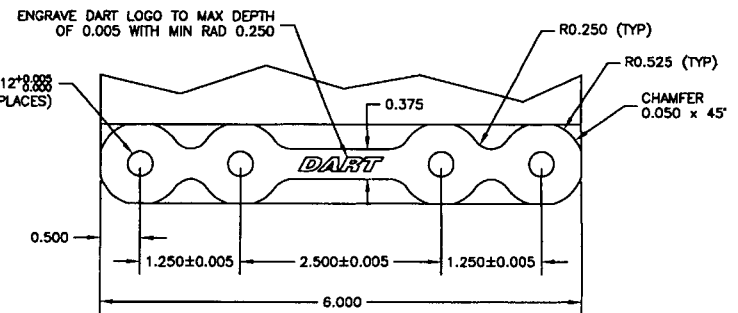
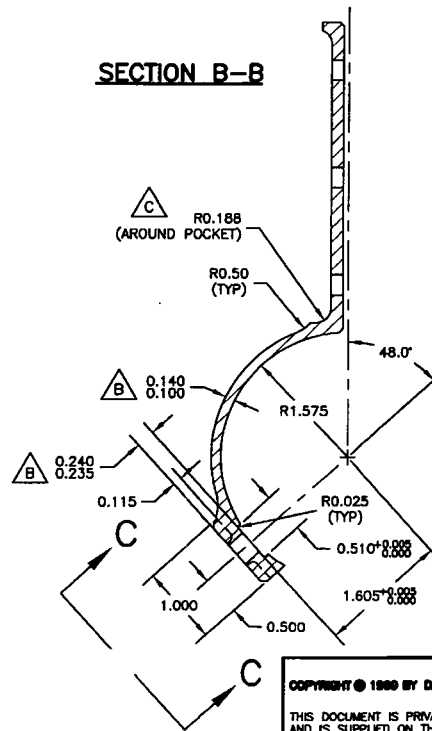
NOTE: Date & initial all entries



SECTION A-A



SECTION B-B



VIEW C-C

#56577
D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2938
DATE		TITLE SADDLE OUTSIDE
06.11.09		SCALE 2:3

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07.02.12

W/O:		WORK ORDER CHANGES					
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